

Work Order ID 78521

78521

Page 1

January-10-12 2:43:01 PM

Item ID: D3003-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ski-Fwd Section
 Start Date: 10/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 24/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/01/10 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3003	Rev A								

100 HAAS CNC VERTICAL MACHINING #1 0.00
100 HAAS I Memo 0.00
 HAAS CNC vertical machine #1 1- Mill as per Folio FA125 Rev: AA & Dwg D3003 Rev: A
 2-Deburr per dwg D3003

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120 QC Memo 0.00
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78521

78521

Page 2

January-10-12 2:43:01 PM

Item ID: D3003-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ski-Fwd Section
 Start Date: 10/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 24/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>78509</u>	0.00							
130									
Packaging	Memo <u>PM</u>	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

6/24/12 (2)

12/1/19 2

12-01-19
(2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January-10-12 2:43:05 PM

Page 1
1

Work Order ID: 78521

78521

Parent Item: D3003-1

D3003-1

Parent Item Name: Ski-Fwd Section

Start Date: 10/01/2012

Required Date: 24/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-05-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	504.6443	4.14	8.715789			
MUHMWB10									**				
UHMW 1" Black													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT018	245	
120035	245	
MAT019	259.6443158	
117321	74.6	
117738	95.8	
117819	83.3	
118814	1.5	
119145	4.44431579	

8.71 56 12601.6

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 78521
Description: Bearpaw		Part Number: D3003-1
Inspection Dwg: D3003	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓		Dim Caliper	BC 05
B	0.200	+/-0.030	.202	✓			
C	0.250	+/-0.010	.256	✓			
D	0.625	+/-0.030	.622	✓			
E	R0.25	+/-0.030	.250	✓			
F	0.25 x 45°	+/-0.030	.240	✓			
G	5.50	+/-0.030	5.507	✓			
H	0.95	+0.030/-0.010	.965	✓			
I	12.75	+/-0.030	12.75	✓			
J	0.375	+/-0.010	.385	✓			
K	3.20	+/-0.030	3.190	✓			
L	12.75	+/-0.030	12.750	✓			
M	0.37	+/-0.030	.375	✓			
N	1.500	+0.010/-0.030	1.498	✓			
O	12.000	+/-0.010	12.000	✓			
P	12.000	+/-0.010	12.000	✓			
Q	14.288	+/-0.010	14.288	✓			
R	4.250	+/-0.010	4.280	✓			
S	6.25	+/-0.030	6.258	✓			
T	Ø0.261	+0.005/-0.000	.260	✓			
U	Ø0.93	+/-0.030	.930	✓			
V	0.30	+0.030/-0.000	.300	✓			
W	44.53	+/-0.030	44.530	✓			

Measured by:	KJ/RF
Date:	12/01/15

Audited by:	[Signature]
Date:	12-01-17

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	P/O K10016	KJ/RF [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

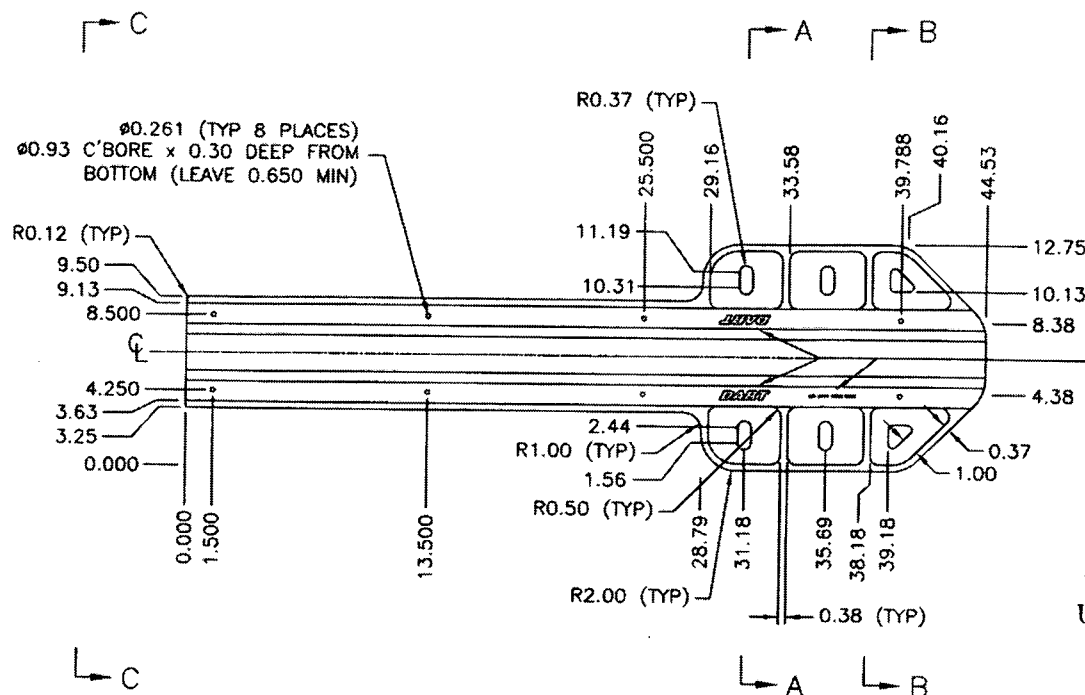
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

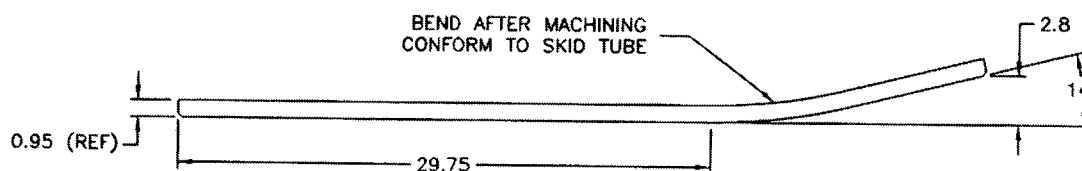


DESIGN	DRAWN BY	DART AEROSPACE LTD
78	78	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
78	78	D3003
DATE	TITLE	REV. A
01.03.22	SKI-FWD SECTION	SHEET 1 OF 2
A	NEW ISSUE	SCALE
01.03.22		1:10

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 (TYPICAL LOCATION AS ILLUSTRATED)



D3003-1 MACHINING DETAIL



D3003-1 BENDING DETAIL

SKI IS SYMMETRIC ABOUT CENTERLINE (EXCEPT FOR ENGRAVING)
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.95)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCON
SUBJECT
WIT
WIT
78521 M.C.S
12/01/10

RELEASED
01.04.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

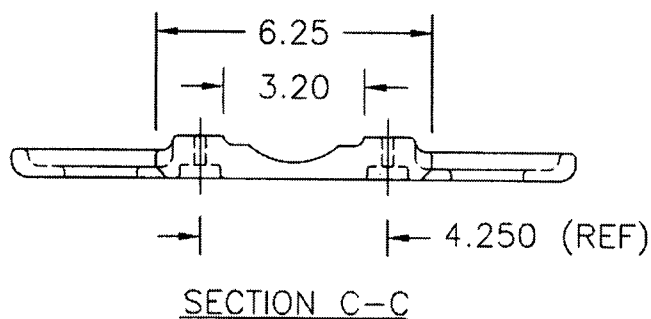
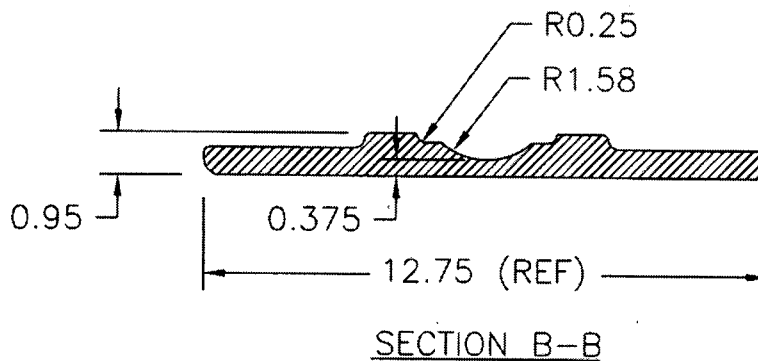
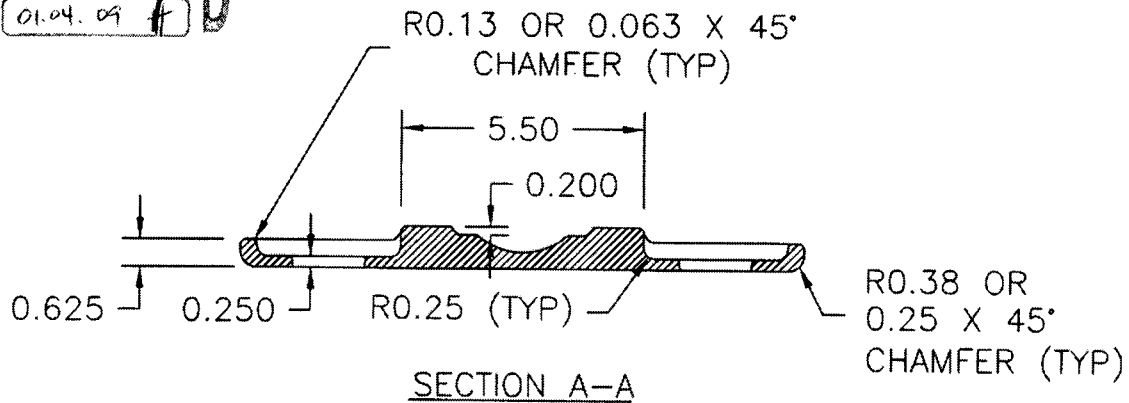
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3003	REV. A SHEET 2 OF 2
DATE 01.03.22		TITLE SKI-FWD SECTION	SCALE 1:4

RELEASED
01.04.09 *[Signature]*



NOTE: ALL SECTIONS ROTATED 90° CCW

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

12521

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries